

Work Order ID 64771

Friday, December 17, 2010 7:48:15 AM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 12/16/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*Date: *10-2-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces								
			<i>SL</i>	<i>11/01/11</i>					
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2274		<i>SL</i>	<i>11/01/11</i>					
								<i>(117)</i>	
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control			<i>SL</i>	<i>11/01/11</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item ID: D2274	Accept		Setup	Start	
Revision ID:					
Item Name: Radius Block				Stop	
Start Date: 12/16/2010	Start Qty: 100.00		Cust Item ID:		
Required Date: 1/19/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		111112		117	6		
140  Small Fab Small Fab	Small Fab Memo Tumble <input type="checkbox"/> Deburr any rough edges after tumbling	0.00 0.00		SAD 11-01-14		117	counted		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				117	6		11/16/14

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Accept

Revisor ID:

Item Name: Radius Block

Start Date: 12/16/2010 Start Qty: 100.00

Required Date: 1/19/2011 Req'd Qty: 100.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

117 BR 11-01-14.

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

11/14 SE (1172)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/14

11.01.14

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Picklist Print

Friday, December 17, 2010 7:48:22 AM

Page 1

Work Order ID: 64771



Parent Item: D2274



Parent Item Name: Radius Block

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP H00.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	99.0243	0.0916	9.642105			



6061-T6 Bar .750 x .125



2 11/01/11

Location

Loc Qty

Loc Code

MAT	80	
116406	80	
MAT01	19.0243	
113608	14.75	
113680	1.4947	
113719	2.7796	

9.7

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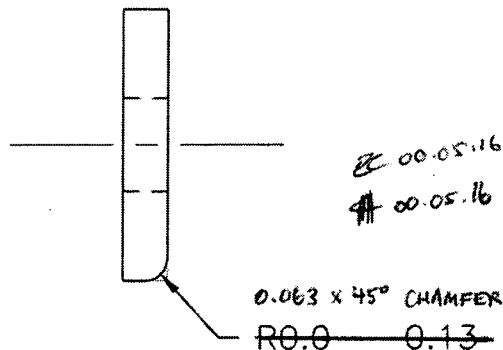
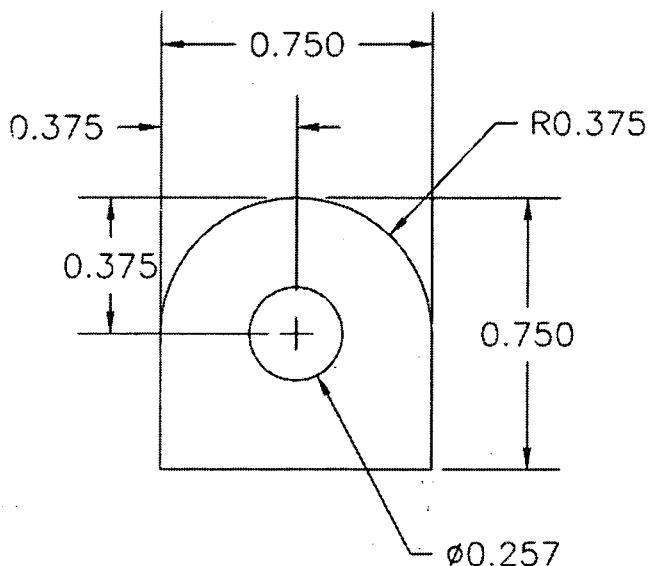
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>CS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44771
BS10-12-17



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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